

75815

October-31-11 12:42:32 PM

Item ID:	D2330-043	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Basket Lid Assembly				Stop	*NS2*
Start Date:	31/10/2011	Start Qty: 1.00	*1*	Cust Item ID:		
Required Date:	14/11/2011	Req'd Qty: 1.00	*1*	Customer:		
Reference:						

Approvals: Process Plan: MLJ Date: 11/10/31 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75815

75815

Page 2

October-31-11 12:42:32 PM

Item ID: D2330-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 31/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 14/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

130

QC Memo 0.00

Quality Control

135	Pressure Wash per QSI005 4.3	0.00							
-----	------------------------------	------	--	--	--	--	--	--	--

135

HandFinish Memo 0.00

Hand Finishing

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

140

Powdercoat Memo 0.00

Powder Coating

START TIME: 2:40
 OVEN TEMPERATURE: 400 OF
 FINISH TIME: 3:10

W119480

12.02.21 (1)

1X8 M-12/02/23

1X8 M-12/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

October-31-11 12:42:32 PM

Item ID: D2330-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 31/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 14/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/29
 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

October-31-11 12:42:38 PM

Page 1

Work Order ID: 75815

75815

Parent Item: D2330-043

D2330-043

Parent Item Name: Basket Lid Assembly

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S KJ
IPP Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verf:EC
IPP REV:J 10.11.30 AS PER DWG REV.H DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2252-1 *D2252-1* Frame		Manufactured	No			100	Each	8.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>					
				WA006				8					
				51941				2					
				58084				6					
D2252-7 *D2252-7* Frame		Manufactured	No			100	Each	8.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>					
				WA006				8					
				73080				3					
				73201				5					
D2327-3 *D2327-3* Spacer Bushing		Manufactured	No			100	Each	23.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				WA				23					
				72963				3					
				74782				20					

**

Pl 12.02.16

**

Pl 12.02.16

**

Pl 12.02.16

377229 → ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 75815

75815

Parent Item: D2330-043

D2330-043

Parent Item Name: Basket Lid Assembly

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2329 Manufactured No

100 Each 3.0000

1 1

D2329

Label Plate

**

Pl 12.05.16

Location

Loc Qty

Loc Code

WA006

3

40488

3

①

D2330-1 Manufactured No

100 Each 0.0000

2 2

D2330-1

Frame

****B75817 → ② Pl 12.05.16**

D2330-15

Manufactured No

100 Each 1.0000

1 1

D2330-15

Frame

**

Pl 12.05.16

Location

Loc Qty

Loc Code

WA

1

70835

1

B70835

~~B70835~~ ①

D2581 Manufactured No

100 Each 23.0000

2 2

D2581

Mounting Bracket

**

Pl 12.05.16

Location

Loc Qty

Loc Code

WA

23

69739

2

70766

2

73762

19

B77045 → ②

D3749-1 Manufactured No

100 Each 12.0000

3 3

D3749-1

Hinge Half

**

Pl 12.05.16

Location

Loc Qty

Loc Code

WA

12

70063

12

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75815

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Parent Item: D2330-043

D2330-043

Parent Item Name: Basket Lid Assembly

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

630.5661

18.9

18.9

M304FX0 75-16F

**

Cpl 12.02.16

Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA

630.5661116

117197

102.9036

117896

53.3264

118153

76.8473

118248

33.0983

118597

29.16788

118955

82.17

119180

253.052632

M 120318 → 18.9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75815 M.L.J

11/10/31

RELEASED
2010-11-25

- NOTES:**
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
 - 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
 - 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: N/A
 - 9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2330	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET ASSEMBLY (206B)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

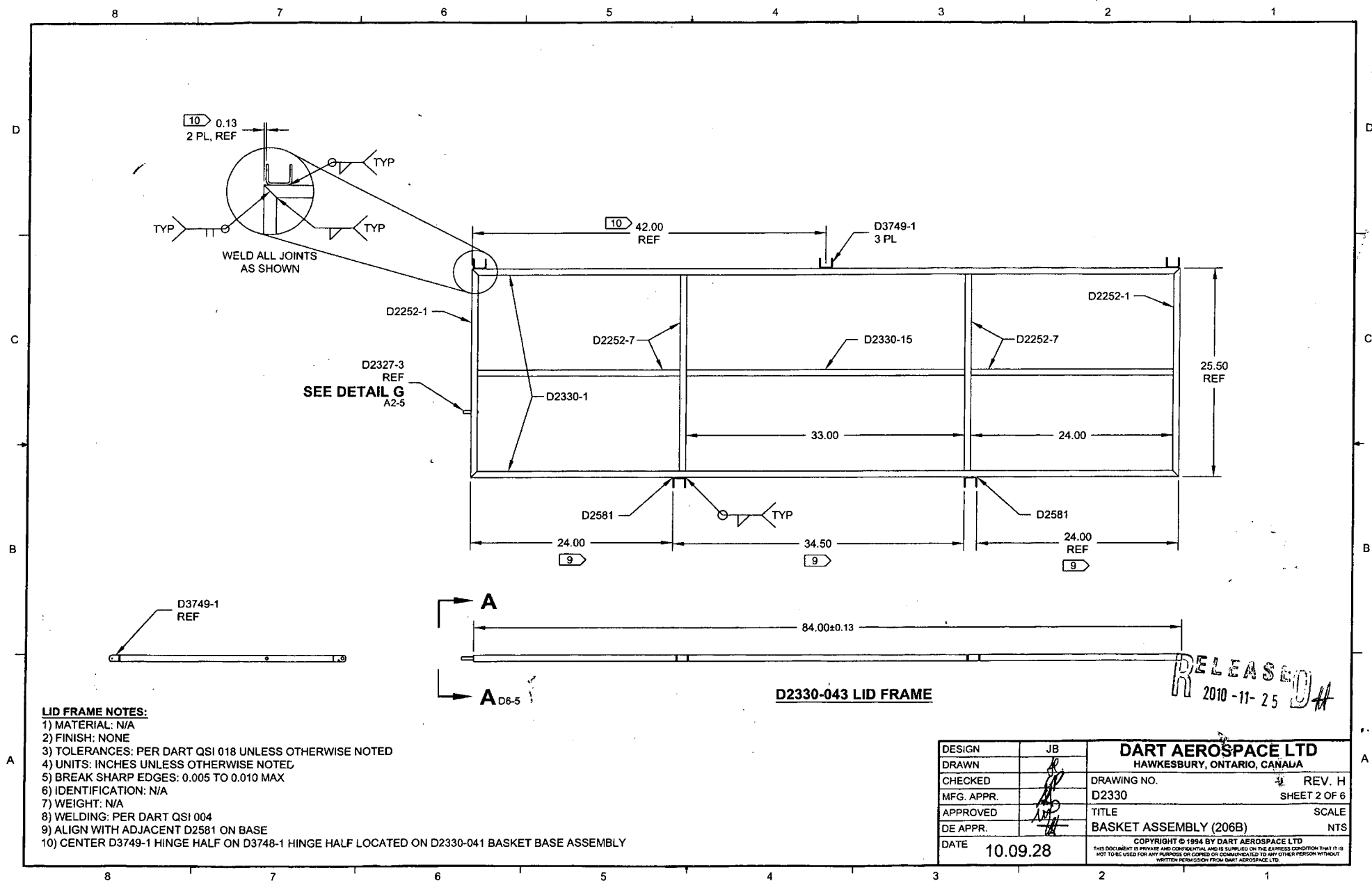
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	10							

NOTE: Date & initial all entries

75815



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

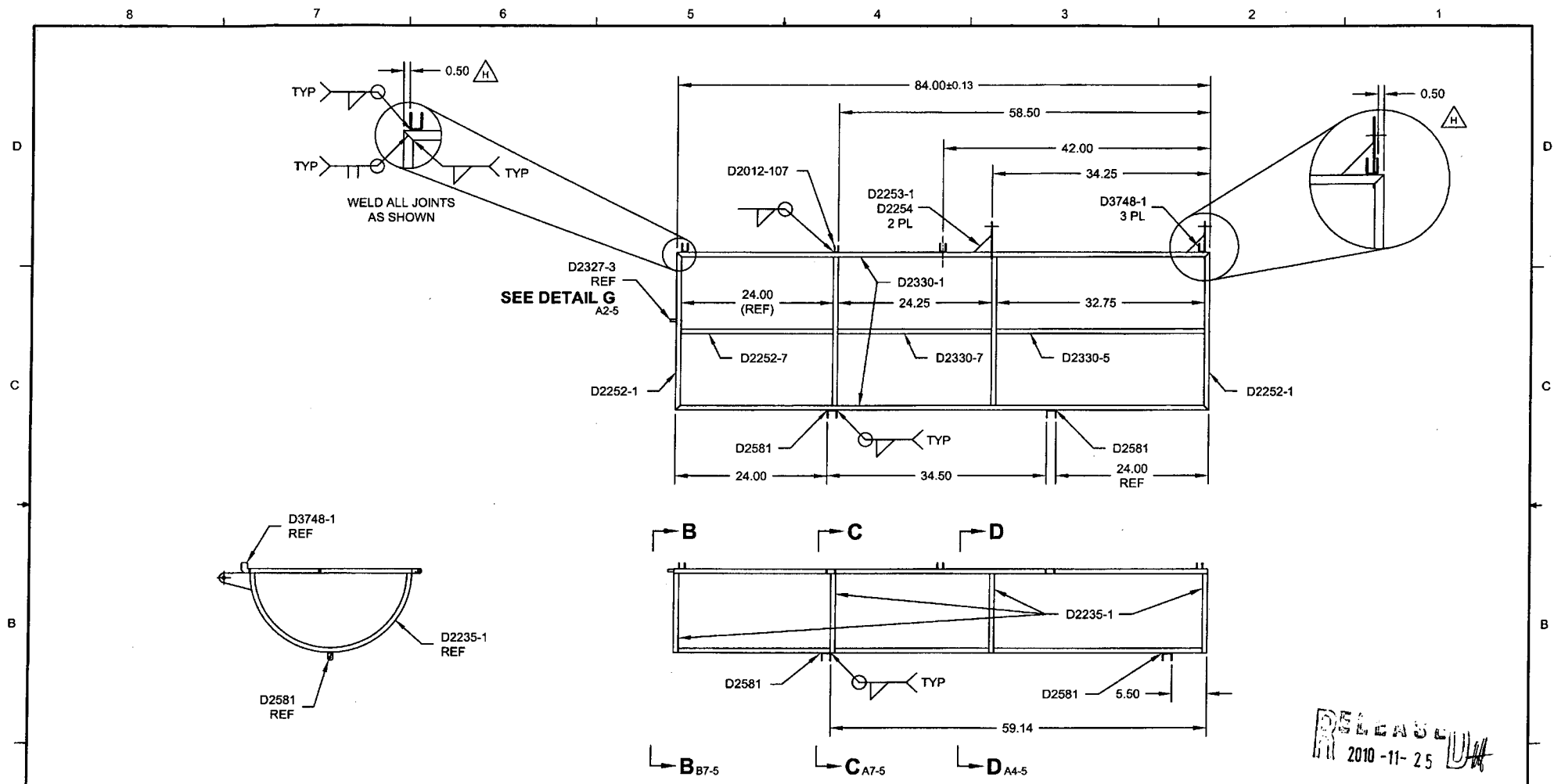
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NOTE: Date & initial all entries

75815



BASE FRAME NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A
 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	For JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. H
MFG. APPR.	M	D2330	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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RELEASE
 2010-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

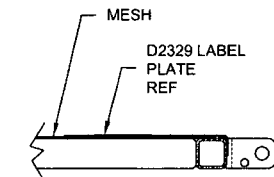
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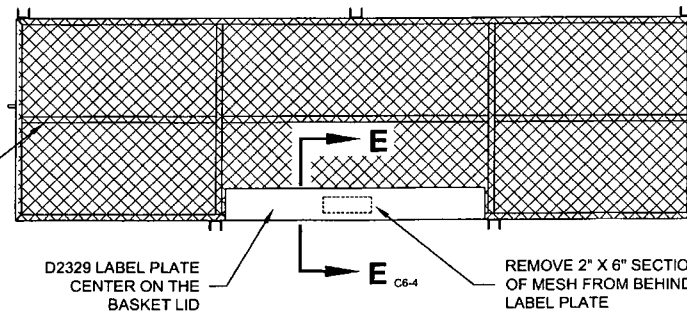
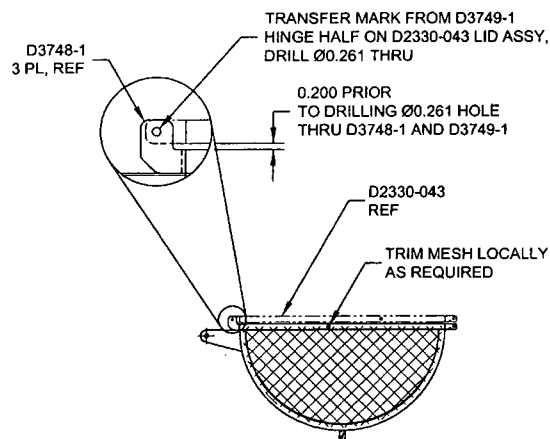
NOTE: Date & initial all entries

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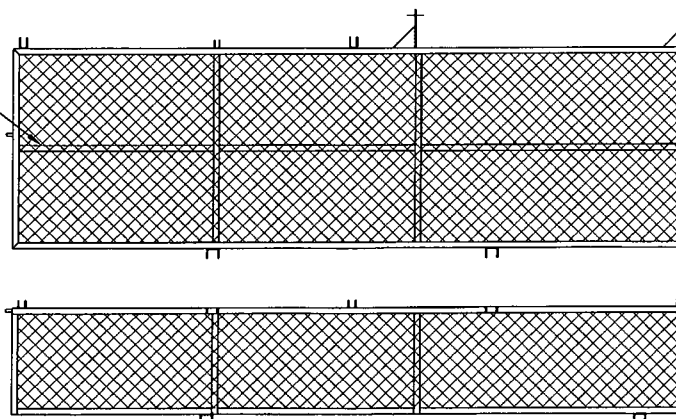


SECTION E-E C3-4
VIEW ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 4 OF 6
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DE APPR.		BASKET ASSEMBLY (206B)	NTS
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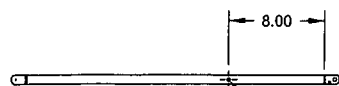
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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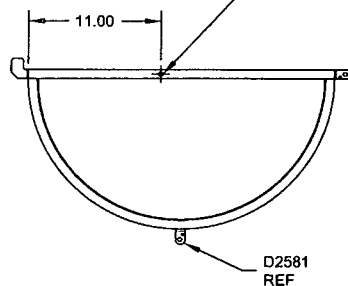
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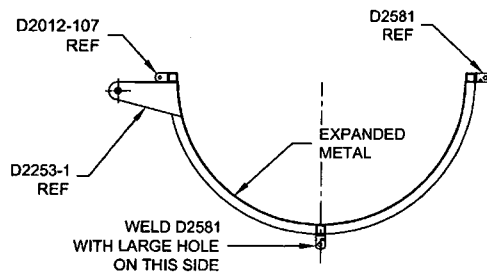


VIEW A-A A6-2

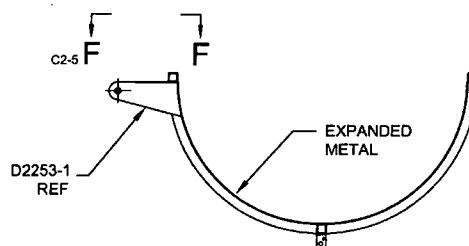
DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL G A2-5



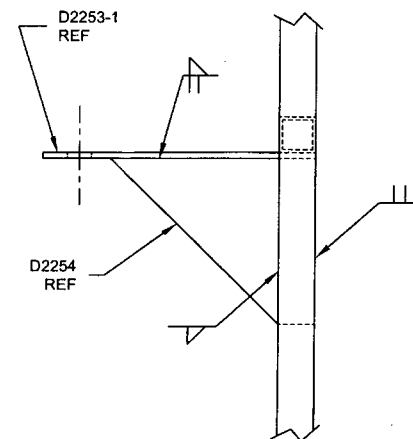
VIEW B-B A5-3



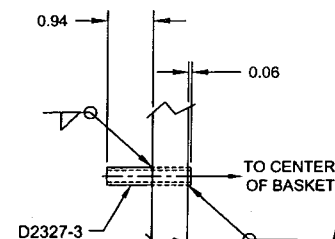
SECTION C-C A4-3



SECTION D-D A3-3



VIEW F-F B6-5
SCALE 4X



DETAIL G
SPACER INSTALLATION
SCALE 4X

RELEASED
2010-11-25

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	A. F. J. P. H.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. H
MFG. APPR.	JP	D2330	SHEET 5 OF 6
APPROVED	JP	TITLE	SCALE
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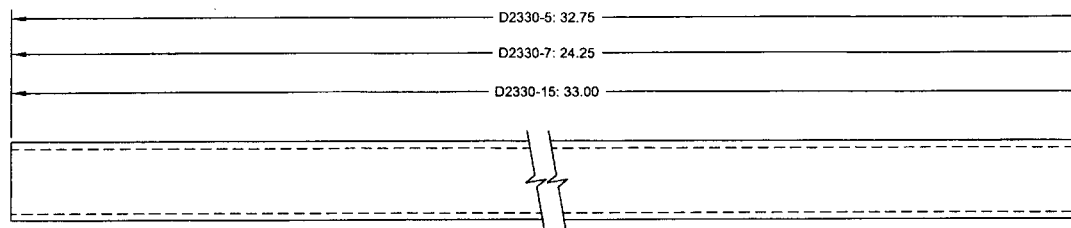
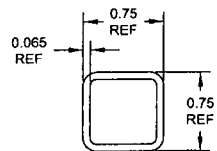
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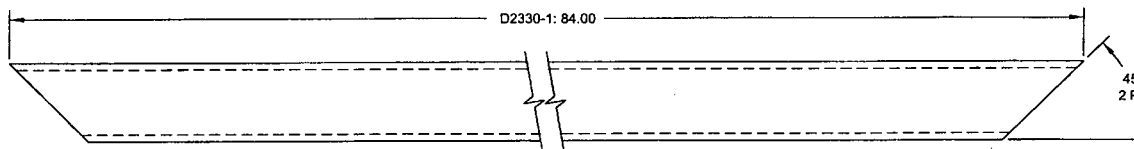
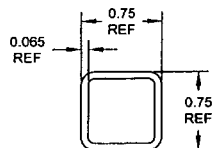
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75815



D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME








D2330-1 FRAME

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2010-11-25

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries